110 HAAS 1

HAAS CNC VERTICAL MACHINING #1

HAAS CNC vertical machine #1

Memo Machine as per dwg D3262

Machine as per Folio FA902 and Dwg D3262 FOLIO REV:

DWG REV: E

TAP USING JIG DT9636

Deburr

0.00

0.00

Work Order ID 10 November-11-13 8:28:34 A			*109	3080*	12 122 8 1327 1		Page 2
Item ID: D3262-5 Revision ID: Item Name: Cap			Accept	*N9000401	იი*	Setup Start Stop	1421
Start Date: 11/11/13 Required Date: 11/15/13 Reference:	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item ID: Customer:			IVITZ
Approvals: Process P		Date:		Date:		Run Start Stop	"INK"
Sequence ID/ Work Center ID	Operation Description QC2- Inspect parts off mac	chine FAI/FAIB	Set Up/ Run Hours	Tool ID Tool # P	lan Accep ode Qty	t Reject Qty	Reject Insp. Number Stamp
120 QC Quality Control	Memo		0.00		12	8	JFC 2013-11-17
*130 *130* QC Quality Control	QC8- Inspect parts - secon	d check	0.00	13-11-20	12	ψ	· · · · · · · · · · · · · · · · · · ·
*140 *110* Packaging Packaging	Identify as per dwg & Stoc	k Location: LG	0.00		12)	,	DAS √ 26 9-89

Work Orde November-11-13				*109	3080*				Page 3
Revision ID:	D3262-5			Accept	*N900040	1100	_	Start Stop	*NS1*
	11/11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item ID: Customer:				141.12
Approvals:	Process Pla	n:	Date:	Tooling:	Date:			Start Stop	*NR1*
	QC:		Date:	SPC (Y/N):	Date:			Р	*NR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Rejective Qty Qty		Reject Insp. Number Stamp
150 + 4 = 0 +		QC21- Final Inspection -	Work Order Release	0.00		(Jam / Dm	13	3/11/20
150 QC Quality Control		Memo	•	0.00			7[]/		
									mF 13-11-

Page 1

Work Order ID:

109080

Parent Item:

Comments:

D3262-5

Parent Item Name:

Cap

IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC

Start Date: 11/11/13

Required Date: 11/15/13

Start Qty: 12.00

Required Qty: 12.00

	DD 10.05.10 verif	fied :EC				•							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.000		Purchased	No			100	f	52.8343	0.96	13			
6061-T6 Bar .500 x 6.00									N				MILL TOPE (MAN) SEE
				Location		Loc Oty	I a	c Code					

IPP Rev:B as per ECN10-571

<u>Location</u> MAT005 52.8342632 112567 0.8192632 122521 16.015 m126647 36

DART AEROSPACE LTD	Work Order:	109080
Description: Cap	Part Number:	D3262-5
Inspection Dwg: D3262 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	loierance	Dimension	Accept	Keject	Inspection	Comments
0.45	+/-0.030	0.443	V .		Caliper	JFC-01
0.25	+/-0.030	0.248			Mic	JFC-02_
Ø0.875	+/-0.010	0.874	/		Caliper	JFC-01
Ø5.005	+0.010/-0.000	5.008			1,	(,
R0.063	+/-0.010	RO063	/		Rad G	Shop
0.080	+/-0.010	0.075			Caliper	JEEO!
0.13	+/-0.030	0.1582			H6"	31006
0.070 x 45°	+/-0.010 x 0.5°	0.070			detho	SFC-07
) ii	
Ø5.165 Ref	+/-0.010	5.16le	/		Caliper	JECOL
1.63	+/-0.030	1-629	/		C.	(1
3.25 Ref	+/-0.030	3.247	<u> </u>		11	``
9/16-18 UNF-3B	N/A	9/10-18	V		TAP	Shop
3/4-16 UNF-3B	N/A	314-16	V		١,	11
0.091	+0.007/-0.008	0.091	<u> </u>		Caliper	DR-16
R0.03	+/-0.010	R0.03			Radio	Shop
R0.02	+0.00/-0.01	R002	/		1 '	(1
45°	+/-0.5°	45°	√ ,		Angl	Shop
30°	+/-0.5°	300			. ત	
Ø0.588	+0.005/-0.000	0.588	V		Caliper	DR-12
Ø0.696	+0.007/-0.008	0,696	V		ζ,	ι,
0.101	+0.008/-0.007	0.101	/		u	. Lı
R0.03	+/-0.010	RO 03	V		Rool	Shop
R0.02	+0.00/-0.01	ROOZ	V		Red G	1.'
45°	+/-0.5°	45	V		Anglo	U
30°	+/-0.5°	30°	V		ζ.	1,
Ø0.771	+0.005/-0.000	0.771			Caliper	DR-16
Ø0.882	+0.008/-0.007	0.882	⊥ ≺		<u> </u>	~ (

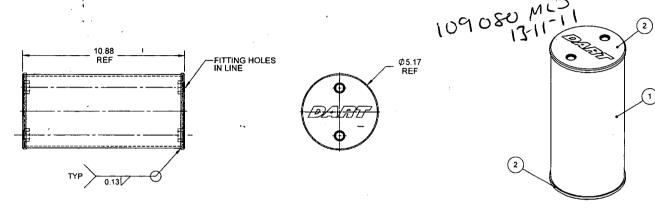
Measured by: JFC	Audited by:	Preliminary Approval:	
Date: 2013-11-17	Date: 3-1/-20	Date:	

Rev	Date	Change	Revised	by	Approved
Α	10.06.07	New Issue	KJ	*()	
	4			ודי	

DQA:			Date:					•					N.	AA PT
QA Closed:			Date:			WORK ORDER NON	-CO	ONFO	RMANCE / UPDATE	14/	o -l. O -d		_	AEROSPACE
QA Closed.			Date.		-					VV	ork Order up	date only		
Work Orde	er:					DISPOSITION			AGAINS'					
						Rework	1		Skid-tube Crosstube	وآ	Water Jet			Engineering
Part N	No.					Scrap	1		Machining Small Fal		Pro	d. Eng. Coor.	\neg	Quality
						Use-as-is		Therr	moforming Finishing	g	4	re/Packaging	\exists	Other
NCR N	No					Suspected Unapproved			Large Fab Composite	9		Supplier		
											-	<u>. </u>		
Root		1			Desci	ription of work order update		nitial	Action		Sign &	-		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	1	QC Inspector
Design														
Doc/Data											ŀ			
Equip/Tooling											ŀ			
Handling/Pre														
Material	<u> </u>	Ì												
Operator	Ц													
Offset/Setup	Н	ŀ												
Process														
Supplier														
Training	Н													
Transport	Н													
Unapproved							<u>L</u>							
	6						FA	JLT CA	TEGORY					
Landii	ng Gear					General		le. 15. 75		_	1		— 1.	<i>-</i>
i	Bending					Bend BOM/Bouts	-	1	Program	-	Outside Dim	-	_	ressure/Forced
	Centre Not Concentric				-	BOM/Route Broken/Damage/Defect	-	Grain		-	Over/Under	-		et-up
ı	Crimp/Kink/Pipple/Mayo				-	, ,	\vdash	Hardwa		-	Part Incorred	· · ·	_	emperature/Cure
	Crimp/Kink/Ripple/Wave Cuffs			vvave	-	Burrs Contamination	-	1	ion Incomplete/Unqualified	-	Part Lost/Mi	ssing		Veld
	Crushing					Countersink	-	1	tions Incomplete/Unclear	-	Part Moved	L	\v	Vrong Stock Pulled
	Heat Treat				-	Cut Too Short	-	Mislabe	gned/off center	-	Positioned V		٦,)+hor
	Inspection Strip in Tube			Tuhe	-	Drawing	\vdash	Misrea		L	Power Loss/	ourge [Ic	Other
		rks/Cha	•	IUDC	-	Drill Holes	\vdash	Off-set				· · · · · · · · · · · · · · · · · · ·		
	_		quence		-	Finish	\vdash	ł	Calibration					
	_		st in Tub	e	-	Fit/Function	\vdash	1	Sequence					
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ITEM	QTY -041	P/N	DESCRIPTION	
	Х	D3262-041	CANISTER ASSEMBLY	
1	1	D3262-1	TUBE	
2	2	D3262-3	CAP	



D3262-041 CANISTER ASSEMBLY

RELEASED 2010 -05- 97

_
NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE
7 MEICHT 0.54 lbs

8

7) WEIGHT: 2.51 lbs 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5) 10.05.03 ADD D3262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004 RF 09.12.30 Ø5.165 WAS Ø5.190 06.08.31 B ADD PRESSURE TESTING OPTION 05.02.14 NEW ISSUE ŔF 04.05.06

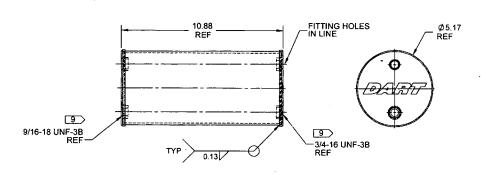
REV.		DESCRIPTION B	Y	DATE					
DESIGN	. RF	DART AEROSPAC	E LTC)					
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA							
CHECKED	45	DRAWING NO.		REV. E					
MFG. APPR.	all	D3262	SHEET 1 OF 5						
APPROVED	10	TITLE		SCALE					
DE APPR.	-#-	FUEL PURGE CANISTE	R	NTS					
DATE 10.0	05.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONCENTUR. AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IN NOT TO BE USED FOR MY PURPOSE OR COMPANIONATED TO ANY OTHER PERSON WITHOUT							

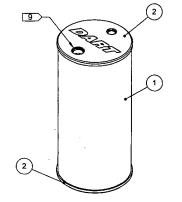
POINT PERMANENT INK MARKER

5

DQA:			Date:				*								
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UI		۱۸/،	ork Order u	ndate only		AEROSPACE
Q (C.03CU.			- Dute.					_							
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT			
					_	Rework]	Skid-tube Crosstube]	Water Jet		Engineering
Part N	Part No.					Scrap]	!	Machining	Small Fab		Prod. Eng. Coor.			Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR No.						Suspected Unapproved]		Large Fab	Composite]	Supplier		
Root					Desci	ription of work order update	Π	nitial	Act	ion		Sign &		$\overline{}$	
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption		Date	Verification	,	QC Inspector
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre	Щ									•					
Material															
Operator	4														
Offset/Setup	_														
Process															
Supplier _	_		:												
Training														1	
Transport	-	:													
Unapproved								UT CAT	FECORY						
Landir	na Go			·····		General	FA	ULI CA	regory						
						Bend] Folio/B	rogram]	: F	\neg	Dunnan /5
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs				BOM/Route	-	Grain	rogram			Outside Dim Over/Under	 -		Pressure/Forced Set-up	
					Broken/Damage/Defect	\vdash	Hardwa	ro.			Part Incorred	 -		Temperature/Cure	
					Burrs	\vdash	1	ion Incomplete/Un	gualified		Part Lost/Mi	-		Weld	
Ì				,		Contamination	\vdash	1	ions Incomplete/U	· ·	-	Part Moved			Wrong Stock Pulled
	Crushing					Countersink	\vdash	1	ned/off center	ATOTO UT		Positioned V			Wiong Stock Funeu
į	Heat Treat			Cut Too Short		Mislabe	•			Power Loss/		\neg	Other		
	Inspection Strip in Tube			Drawing		Misread				J. 5 5. 2000)	o~ L	_			
Ì		larks/Ch	٠.			Drill Holes	—	Off-set						_	
	Ti	urning Se	equence			Finish	\vdash	ł	Calibration					_	
	Πv	/ave/Tw	ist in Tuh	ie.		Fit/Function		ł	Coguence						

 				1	A. B. A. L.
		2	1	100	7080
ITEM	QTY -043	P/N	DESCRIPTION		
	X	D3262-043	CANISTER ASSEMBLY		1
11	1	D3262-1	TUBE		
2	2	D3262-5	CAP		





D3262-043 CANISTER ASSEMBLY

RELEASED

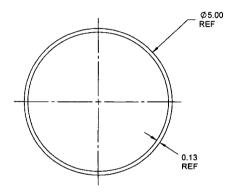
NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.50 ibs
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN RF		DART AEROSPACE L	TD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANA			
CHECKED	\$	DRAWING NO.	REV. E		
MFG. APPR.	9/	D3262	SHEET 2 OF 5		
APPROVED	10	TITLE	SCALE	١,	
DE APPR.	-4	FUEL PURGE CANISTER	NTS		
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPAC THE DOCAMENT IS MINISTER AND COMPRIENTIA, AND IS SUPPLIED ON THE EXPRES NOT TO BE USED FOR ANY PURPOSE OR COMPED OR COMMUNICATED TO ANY OT WATTEN PERMISSION FROM CART LERGISMOSE LTD.	ES CONDITION THAT IT IS		

DQA: Date:					~ <u>~</u>									
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only								
						DISPOSITION AGAINST					PARTMENT	· ·		
Work Orde	er: _						· I			_	•	_		
5						Rework			i	osstube	_	Water Jet	Engineering	
Part N	NO. –					Scrap		Machining Small Fab				d. Eng. Coor.	Quality	
NCD A	1-					Use-as-is		Thern	- - -	inishing	Rec/Stor	re/Packaging	Other	
NCR N	NO				_	Suspected Unapproved			Large Fab Con	mposite		Supplier	[]	
Root		i			Descr	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector	
Design														
Doc/Data	Ш													
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup											!			
Process														
Supplier	\sqcup													
Training	\Box			1										
Transport	\Box													
Unapproved														
		•					FAL	ULT CAT	TEGORY					
Landii	_					General		1		_	Ī	_		
	-	Bending			<u> </u>	Bend	Щ	1	Program	—	Outside Dim	├	Pressure/Forced	
	\vdash	Centre Not Concentric Cracks			<u> </u>	BOM/Route		Grain			Over/Under	tolerance	Set-up	
						Broken/Damage/Defect		Hardwa	re		Part Incorred	t	Temperature/Cure	
	Crimp/Kink/Ripple/Wave			/Wave		Burrs		Inspect	ion Incomplete/Unqualif	fied	Part Lost/Mi	ssing ·	Weld	
	-	Cuffs			<u> </u>	Contamination		ł	ions Incomplete/Unclear	ır	Part Moved		Wrong Stock Pulled	
	-	Crushing				Countersink		1	ned/off center		Positioned W	/rong		
	-	Heat Trea			<u> </u>	Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other	
	_	nspection	•	Tube		Drawing	Щ	Misread						
	-	Marks/Ch				Drill Holes		Off-set						
		Turning S			<u> </u>	Finish		Out of (Calibration					
	Wave/Twist in Tube					Fit/Function Out of Sequence								

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109080



D3262-1 TUBE

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6T5.000W.125
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.96 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

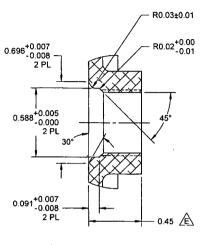
DESIGN	RF	DART AEROSPACE LTD							
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA							
CHECKED	\$	DRAWING NO.	REV. E						
MFG. APPR.	2/	D3262	SHEET 3 OF 5						
APPROVED	10	TITLE	SCALE						
DE APPR.	-111	FUEL PURGE CANISTER	NTS						
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENCE HAS DEPUBLIS CONFIDENT THAT IT IS NOT TO BE USED FOR ANY AUTHORS ON COMPANY ON CONFIDENCE THAT IT IS NOT TO BE USED FOR ANY AUTHORS ON COMPANY.							

					×									
QA Closed:		Date:		WORK OR	WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
27.0.0300		Dute.												
Work Order:				DISPOS	SITION			AGAINST D	EPARTMENT	/PROCESS				
				_	Rework		Skid-tube	Crosstube		Water Jet	Engineering			
Part No.	•			_ 1	Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
					Use-as-is	The	moforming	Finishing	Rec/Sto	Other				
NCR No.	•			Suspected Una	approved		Large Fab	Composite		Supplier				
Root				Description of work o	rder update	Initial	Act	tion	Sign &					
Cause	Date	Step	Qty	or non-conform	· · · · · · · · · · · · · · · · · · ·	Chief En	g Desci	ription	Date	Verification	QC Inspector			
Design														
Doc/Data	_													
Equip/Tooling	_													
Handling/Pre	4				ļ									
Material	4													
Operator	_									:				
Offset/Setup	4 .													
Process	-													
Supplier	4													
Training	-]											
Transport	-				İ									
Unapproved			<u> </u>											
l andina	·					AULT CA	TEGORY							
Landing	7			General	' <u>-</u>	¬₋	'a	Г	–		٦ .			
<u> </u>	Bending	t Canaan		Bend	<u> </u>	⊣ '	Program	-	Outside Dim	 	Pressure/Forced			
	Centre No Cracks	Concen	itric	BOM/Route	/D-f+	Grain		<u> </u>	Over/Under	<u> </u>	Set-up			
	=	J./Dinnlo	Maria	Broken/Damage	Profesect	Hardy			Part Incorre		Temperature/Cure			
}	Crimp/Kin	ik/kippie/	/ wave	Burrs			tion Incomplete/Ur	· —	Part Lost/Mi	issing	Weld			
 	Crushins		Contamination Countersink	+	_	ctions Incomplete/l	Inclear ·	Part Moved	L	Wrong Stock Pulled				
H	Crushing Heat Trea	+		Cut Too Short	-		gned/off center	F	Positioned V Power Loss/	_	ا ا			
<u> </u>	Inspection		Tubo	 	<u> </u>		Mislabeled			Surge	Other			
 -	Marks/Ch		Tube	Drawing Drill Holes	-	Misre								
-	⊣			Finish	 	Off-se	Calibration							
		ring Sequence Finish ve/Twist in Tube Fit/Function				 -	Sequence							

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Æ 0.25 Ø0.875 2 PL \$5.005+0.010 -0.000 R0.063 TYP 0.070 x 45° CHAMFER 0.080 0.13 TYP

DRILL THRU Ø0.516 (33/64 DRILL), TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879 Ø5.165 2 PL REF 1.63 Œ 3.25 REF 6



DETAIL B C7-4

SECTION A-A C5-4

D3262-3 CAP

1 2010 -05- 0 A

NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B

REF. DART SPEC. M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE 'DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP

(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN

8

8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN **DART AEROSPACE LTD** DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. E D3262 MFG. APPR. SHEET 4 OF 5 TITLE APPROVED SCALE FUEL PURGE CANISTER

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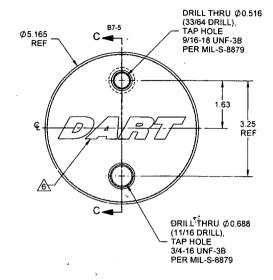
THIS DOCUMENT IS PRIVATE AND COMPRESSION AND SUPPLYED ON THE EMPESSION OF THE CONTROL OF THE CO DE APPR. NTS DATE 10.05.03

DQA: Date:															7.
QA Closed:	•	Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only										
					DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Work Orde	er:	, 		_		,			_	_ .	•	_			
Dt A	.1 -				Rework			Skid-tube	Crosstube	Water Jet			- ¹	Engineering	Ì
Part N	NO				Scrap		i i	Machining	Small Fab	4 .	Prod. Eng. Coor.			Quality	
NCR N	No				Use-as-is		inerr	noforming	Finishing	— ^{ке}	c/5to	re/Packaging		Other	
NCK I	···.	1			Suspected Unapproved]		Large Fab	Composite			Supplier			
Root				Desci	ription of work order update		Initial	Act	tion	Sign	า &		Т		_
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Da	ite '	Verification	. [QC Inspector	
Design									-						
Doc/Data															
Equip/Tooling									*						
Handling/Pre															
Material															
Operator															
Offset/Setup										1					
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Supplier															
Training															
Transport															
Unapproved								·				ĺ			
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Landi	ng Gear				General		_		_			_			
	Bendin	g			Bend		Folio/F	rogram		Outsid	de Dim	ensions	Pr	essure/Forced	
Centre Not Concentric			BOM/Route		Grain		[Over/	Under	tolerance	Se	et-up			
·	Cracks Crimp/Kink/Ripple/Wave			Broken/Damage/Defect		Hardwa	ire		Part Ir	ncorre	ct	Te	mperature/Cure		
					Burrs		Inspect	ion Incomplete/Ui	nqualified	Part L	ost/Mi	issing	w	eld	
·	Cuffs				Contamination		Instruct	ions Incomplete/l	Unclear	Part N	Noved	Γ	\neg w	rong Stock Pulled	
	Crushir	ıg			Countersink		Misalig	ned/off center		Positio	oned V	Vrong			
	Heat Tr	eat			Cut Too Short		Mislabe	eled	[Powei	r Loss/	Surge	Ot	her	
		ion Strip in	Tube		Drawing		Misread	t	_						
	Marks/	Chatter			Drill Holes		Off-set							•	
:		g Sequence			Finish		Out of	Calibration							_
	Wave/	Twist in Tul	be		Fit/Function		Out of	Sequence							

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0.25 Ø0.875 2 PL -D C2-5 ⁵Ø5.005^{+0.010} R0.063 TYP -E A2-5 0.070 x 45° CHAMFER 0.13 E 0.080 TYP

SECTION C-C D5-5



D3262-5 CAP

RELEASED 2010 -05- B7 DETAIL E 87-5

R0.03±0.01 R0.02^{+0.00}

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0.45

R0.03±0.01

R0.02^{+0.00}

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DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. E D3262 MFG. APPR. SHEET 5 OF 5 TITLE APPROVED SCALE FUEL PURGE CANISTER

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THIS DOCUMENT OF ARRON PROCESS AND THE CONTROL ACCOUNTS NOT TO BE USED ON ARROW PURGO ON CORES ON COMMENCE TO ARROW PURGO WHITTEN PURGO ARROW PURGO ON COMPANION TO ARROW PURGO ON THE CONTROL ARROW PURGO DE APPR DATE 10.05.03

NOTES: 1) MATÉRIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN

7) WEIGHT: 0.27 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE

3

0.091+0.007

Ø0.696^{+0.007}

Ø0.588+0.005 -0.000

0.101+0.008

Ø0.882^{+0.008}_{-0.007}

Ø0.771+0.905 -0.000

DQA:		Date:			_						· · · · · · · · · · · · · · · · · · ·	TELLACE		
			WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed: Date:					Work Order update only									
Work Order:			DISPOSITION	ITION AGAINST DEPARTMENT/PROCESS										
	•					Rework	1		Skid-tube	Crosstube	1	WaterJet	Engineering	
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng Coor	Quality	
NCR No.			<u> </u>	1 '			Thermoforming Finishing Large Fab Composite			Rec/Store/Packaging Oth				
Root					Desc	ription of work order update	1	nitial	Actio	on į	Sign &		CONTRACTOR OF THE PARTY OF THE	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector	
Design Doc/Data		:												
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Process														
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Training														
Transport Unapproved	-													
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Landi	ng G	Gear				General								
		Bending				Bend		Folio/F	Program	Γ	Outside Dir	nensions	Pressure/Forced	
Centre No		ot Concer	ntric		BOM/Route		Grain				THE RESERVE AND PORT OF THE PERSON OF THE PE	Set-up		
		Cracks		*		Broken/Damage/Defect		Hardwa	ire :		Part Incorre	791 10	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs &-		Inspect	ion Incomplete/Unq	jualified	Part Lost/N	- 15 Page 1	Weld	
		Cuffs				Contamination		Instruct	ions Incomplete/Un	nclear	Part Moved		Wrong Stock Pulled	
 - 		Crushing				Countersink		Misalig	ned/off center	·	Positioned	and the second second		
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss	/Surge	Other	
		Inspection	n Strip in	Tube		Drawing		Misread	d	_				
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	•			Finish		Out of 0	Calibration				<u> </u>	
1.	Wave/Twist in Tube			Fit/Function .		Out of 9	Seauence							

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